

Work Order ID 78782

78782

Page 1

January-16-12 7:41:25 AM

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Long RH
 Start Date: 16/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/16 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Document Control Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

110 0.00
110 Large Fab
 Large Fab Memo 0.00
 Large Fab 1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 119785

3-Grind End Plate flush 119712 → Ae 12/02/17

M.L.J 12/03/06
(10)

12.02.13 10 φ

(10) φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

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Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

10 0 BE 12/02/17

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

12 02 21 (10)

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10X0 M-1 12/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

180	Large Fab	0.00							
180									
Large Fab	Memo	0.00							
Large Fab									

- 1-Assemble Leg Assembly as per Dwg D3272.
 2-Leave one rivet out until welding is complete.
 3-Bevel Aft end for welding
 4-Inspect for foreign object as per QSI 024
 5-Weld Aft End Plate as per QSI 004 & Dwg D3272
 A/RAluminum Rod ~~119785~~
 6-Grind End Plate flush
 7-Install last rivet as per Dwg.

12.02.29
 Ae 12/02/23

(110) 0

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

10Xφ m-12/03/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

10 X 10 M 12/03/03
RH

230 Wing Walk as per dwg QSI005 4.4 Batch 120125 0.00

230

HandFinish

Hand Finishing

Memo

10
RH.

BR 12-3-5

240 QC3- Inspect Part Finish 0.00

240

QC

Quality Control

Memo

0.00

10 RH 12/03/06

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Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

250

Packaging

Memo

0.00

Packaging

0.00

260

QC

Memo

0.00

Quality Control

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location:

HALL

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Start Date: 16/01/2012 Start Qty: 10.00

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 12/03/08

01203-8

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 78782

78782

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	30.0000	1	10			
D3272-1									**			12.02.11	
Step													

Location	Loc Qty	Loc Code
ST	-10	
WA	40	
77650	10	
77651	10	
77653	10	

D3067-1

Manufactured No

110

Each

127.0000

1

10

D3067-1

**

End Plate

Location	Loc Qty	Loc Code
WA	120	
78022	120	
WA016	7	
67582	2	
68214	1	
76179	4	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 78782

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No

110 Each

78.0000 2 20

D3219-1

Plate

**

12.02.13

Location

Loc Qty

Loc Code

WA016 B78763 78
73410 12
76226 14
77674 52

20

D3066-1 Manufactured No

180 Each

96.0000 2 20

D3066-1

Spacer

**

B78605 x20 Ae 12/02/23

Location

Loc Qty

Loc Code

WA 70
77564 70
WA015 26
76180 26

20

MS20600-AD4W4 Purchased No

180 Each

2,386.000 16 160

MS20600-AD4W4

Rivets

**

B120308 (160) Ae 12/02/23

Location

Loc Qty

Loc Code

ST321 2381
116188 59
117364 253
117601 200
117885 195
118840 1089
119860 30
119883 555
WA018 5
116712 5

160

January-16-12 7:41:29 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78782

78782

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041 Manufactured No 180 Each 12.0000 1 10
D3065-041 ** 879419 (10) Ac 12/02/23
 Step Leg Assembly Hi

Location	Loc Qty	Loc Code
WA	12	
66149	0	
77054	12	

D3067-1 Manufactured No 180 Each 127.0000 1 10
D3067-1 ** 12.02.29
 End Plate

Location	Loc Qty	Loc Code
WA <u>B79607</u>	120	
78022	120	
WA016	7	
67582	2	
68214	1	
76179	4	

AN3-35A Purchased No 250 Each 243.0000 2 20
 S410 ***AN3-35A*** ** 20
 Bolt

Location	Loc Qty	Loc Code
ST353	243	
119449	43	
120187	200	

D3235-1 Manufactured No 250 Each 47.0000 2 20
 S410 ***D3235-1*** ** 20
 Mounting Lug

Location	Loc Qty	Loc Code
ST481	47	
<u>75547</u>	47	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3278-041 Manufactured No

250 Each

11.0000 1

D3278-041

Support Assembly

**

10

B78794

SP

Location

Loc Qty

Loc Code

ST481

11

76169

11

AN960JD416 NAS1149D0463J Purchased No

250 Each

0.0000 16

AN960.ID416

Washer

**

160

M100 644

SP

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000 4

AN960.ID516

Washer

**

40

M118644

SP

AN5-36A Purchased No

250 Each

245.0000 2

AN5-36A

Bolt

**

20

SP

SP

Location

Loc Qty

Loc Code

ST340

245

119641

45

120187

200

D2618 Manufactured No

250 Each

152.0000 2

D2618

Bushing

**

20

20

B78537

12/3/7

SP

SP

Location

Loc Qty

Loc Code

ST012

152

76130

52

77563

100

January-16-12 7:41:29 AM

Shop Packet Print

Page 4

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2230-3 Manufactured No 250 Each 72.0000 4 40

D2230-3

Lug

**

378593

Location

Loc Qty

Loc Code

ST480

72

53881

4

70973

1

75546

1

76642

66

D2856-400 Manufactured No 250 f 113.7673 1.2 12

D2856-400

Abraison Strip

**

12/3/7

Location

Loc Qty

Loc Code

ST409

113.767258

63735

0.6696

68076

0.3149

71164

21.66

73491

91.122758

*cut (2) D2856-400-720 as per dwg

MS21042L3

MS21042L3

Nut

Purchased No 250 Each 5,839.000 2 20

**

12/3/7

Location

Loc Qty

Loc Code

ST300

5839

117441

16

117885

32

118451

5

118927

3

119017

5309

119075

474

20

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Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Purchased No

250 Each

1,478.000 8

80

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

1478

119449

478

120187

1000

Purchased No

250 Each

2,018.000 2

20

MS21042L5

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

ST300

2018

116105

5

116548

43

117611

50

118179

420

119109

1500

Purchased No

250 Each

7,507.000 8

80

MS21042L4

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

7507

117441

67

117601

342

118451

133

119017

1965

119075

5000

Purchased No

250 Each

0.0000 4

40

AN960JD10

NAS1149D0363J

AN960JD10

Washer

**

m1195 37

12/3/7

SP 100

W/O:		WORK ORDER CHANGES					
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DESIGN <i>gp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

78782-M.C.5
12/01/16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

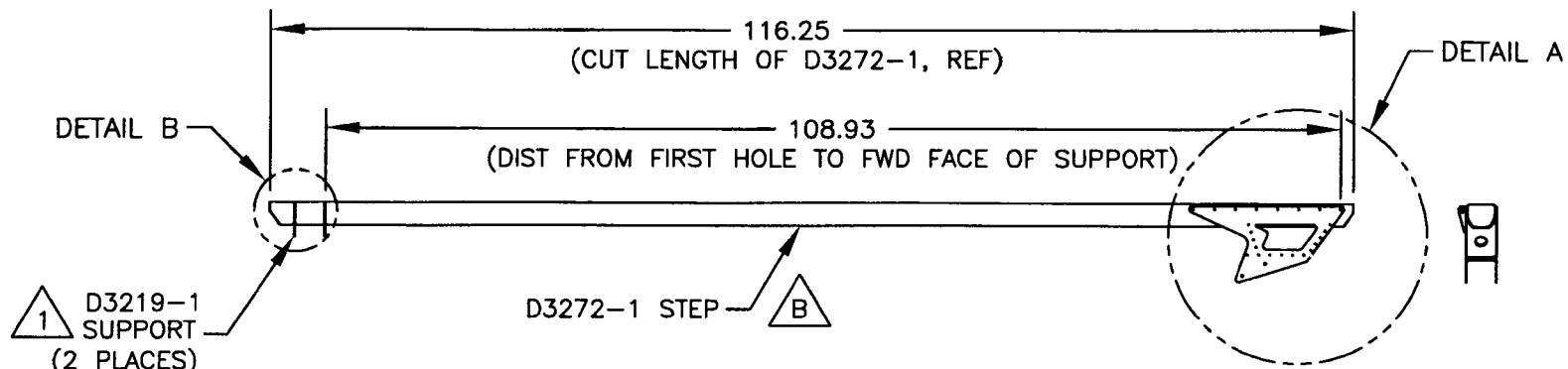
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

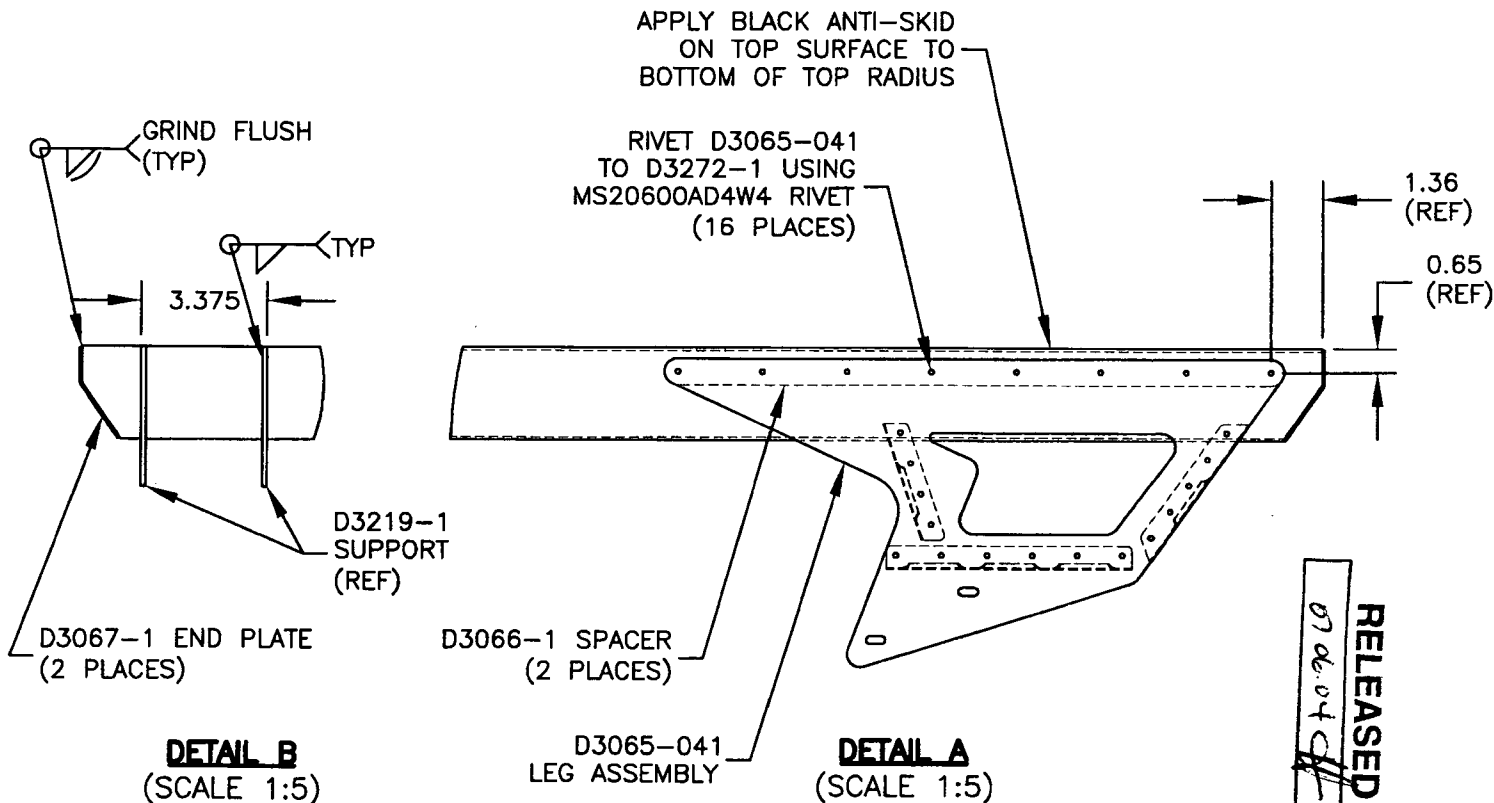


DESIGN	90	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 2 OF 3
		SCALE	1:20	

78782



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

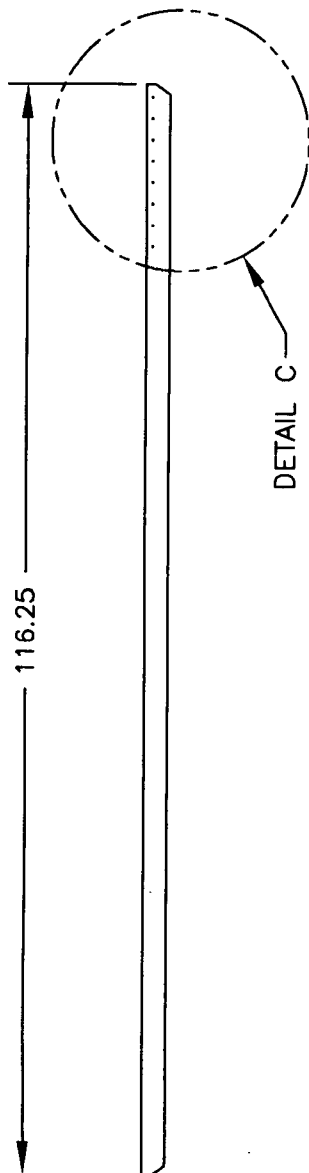
NOTE: Date & initial all entries



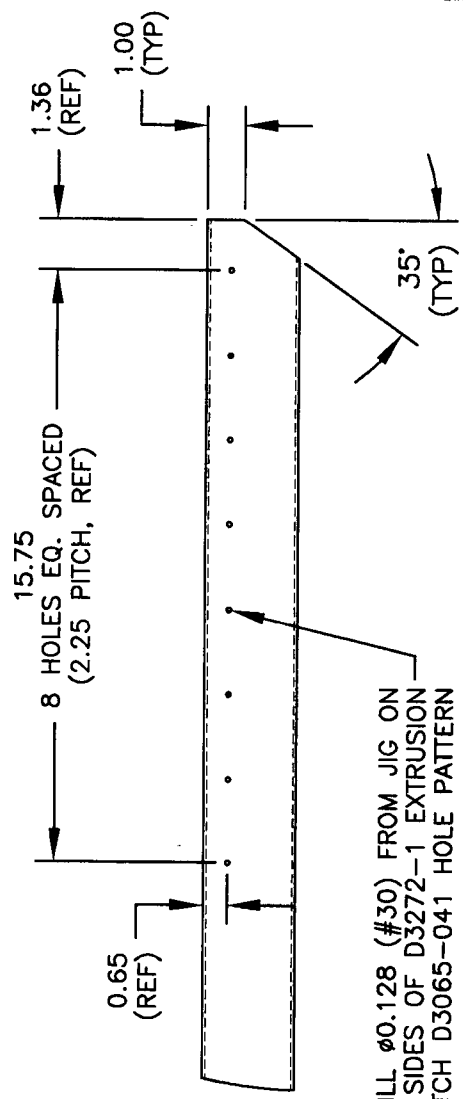
DESIGN GP	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04



DETAIL C
B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78782

78782

January-16-12 7:41:25 AM

Item ID: D350-591-312

Accept

N900040100

Setup Start ***NS**

Revision ID:

Stop ***NS**

Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NF**

Approvals: Process Plan: MLJ

Date: 12/01/16 Tooling:

Date:

Stop ***NF**

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number
Draw Nbr	Revision Nbr							
D3272	Rev B							
100	DOCUMENT CONTROL	0.00						
100								
DC	Memo	0.00						
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001							
110	Large Fab	0.00						
110								
Large Fab	Memo	0.00						
Large Fab	1-Bevel end for welding FWD ONLY							
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg							
	D3272							
	A/R Aluminum Rod <u>119785</u>							
	<u>119772</u>							
	3-Grind End Plate flush							

12.02.13 10 φ

Ac 12/02/17

10 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**

Date: 08.10.06